Quality Control

June-10-13 12:37:47 PM Item ID: D3067-1 Accept Setup Start *N900040100* **Revision ID:** Item Name: End Plate *140* **Start Date:** 6/10/13 **Start Qty: 140.00** Cust Item ID: Required Date: 6/24/13 Req'd Qty: 140.00 *140* **Customer:** Reference: Run Process Plan: MUS Date: /3-06-10 Tooling: Approvals: Date: Stop QC: _____ Date: ____ SPC (Y/N): Date: Sequence ID/ Operation Tool ID Set Up/ Tool # Plan Reject Reject Accept Insp. Work Center ID **Description** Code Qty Qty Number Stamp **Run Hours Draw Nbr** Revision Nbr D3067 Rev A 100 0.00 FLOW WATER JET *100* 165 Q 13-6-14 Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg D3067 Dwg Rev: 5052.623 Prog Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 165 A 136-14 *110* QC 0.00 Memo Quality Control 120 QC8- Inspect parts - second check 0.00 *120* 165 13-06-14 QC

0.00

Memo

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						Rework]		Skid-tube			Water Jet		Engineering	
Part N	lo					Scrap]	Machining Small Fab				Prod. Eng. Coor.			Quality
						Use-as-is]	Therr	noforming	Finishing		Rec/Sto	re/Packaging		Other
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June-10-13 12:37:47 PM

Item ID: D3067-1 Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: End Plate *140* **Start Date:** 6/10/13 **Start Qty: 140.00 Cust Item ID:** Required Date: 6/24/13 Req'd Qty: 140.00 *140* **Customer:** Reference: Start Run Approvals: Process Plan: ___ Date: **Tooling:** Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Reject Operation Set Up/ Tool ID Tool # Plan Reject Accept **Work Center ID** Description Code Qty Qty **Run Hours** 130 0.00 NC BRAKE *130* Brake NC 0.00 Memo Brake NC Bend as per Dwg D3067 140 QC5- Inspect part completeness to step on W/O *140* QC Memo Quality Control Identify as per dwg & Stock Location: 1/1/14 .803 0.00 150 *150*

Packaging

Packaging

Memo

*** STOCK IN STEP CELL***

0.00

Number Stamp

Insp.

DQA:		_ Date:			_									
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					Rework			Skid-tube Crosstul	oe[Water Jet	Engineering		
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					Use-as-is		Thern	noforming Finishi	าg	Rec/Sto	re/Packaging	Other		
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	Cracks			<u> </u>	Broken/Damage/Defect		Hardwa	re		Part Incorred	it	Temperature/Cure		
		ink/Ripple	e/Wave	<u> </u>	Burrs		Inspecti	on Incomplete/Unqualified		Part Lost/Mi	ssing	Weld		
	Cuffs			<u> </u>	Contamination		ł	ions Incomplete/Unclear	<u> </u>	Part Moved		Wrong Stock Pulled		
	Crushing				Countersink		1	ned/off center	L	Positioned V		_		
	Heat Treat			Cut Too Short		Mislabe	led		Power Loss/	Surge	Other			
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	Wave/Twist in Tube				Fit/Function		Out of S	equence						

June-10-13 12:37:47 PM Item ID: D3067-1 Accept *N900040100* Setup Start **Revision ID:** Item Name: End Plate **Start Date:** 6/10/13 **Start Qty: 140.00 Cust Item ID:** Required Date: 6/24/13 Req'd Qty: 140.00 **Customer:** Reference: Run Process Plan: Date: **Tooling:** Approvals: Date: Stop Date:_____ SPC (Y/N): Date: Sequence ID/ Operation Tool ID Tool # Plan Set Up/ Reject Reject Accept Insp. Work Center ID Description Code Qty Number Stamp **Run Hours** Qty 160 QC21- Final Inspection - Work Order Release 0.00 *160* QC 0.00 Memo Quality Control

Mr -18

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		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unq	ualified	Part Lost/Mi	ssing		Weld
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		Crushing				Countersink		Misalig	ned/off center		Positioned V	۔ Vrong		
		Heat Trea	it			Cut Too Short		Mislabe			Power Loss/	Surge		Other
	ا	Inspection	n Strip in	Tube		Drawing		Misread	d					
	ال	Marks/Ch	atter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of (Calibration					
	Wave/Twist in Tube				Fit/Function		Out of 9	Sequence						

Picklist Print

June-10-13 12:37:51 PM

Work Order ID: 102686

Parent Item:

D3067-1

Parent Item Name: End Plate

102686

D3067-1

Start Date: 6/10/13

Required Date: 6/24/13

Page 1

Start Qty: 140.00

Required Qty: 140.00

Comments:

IPP: 03.01.21 Remove step 6 (Deburr)

KJ

IPP Rev:B Now on Water jet 06-06-16 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty		Date ssued	Status
M5052H32S.063		Purchased	No			100	sf	164.8653	0.0625	9.210526			
*M5052H3	328 063	*							**	A	13-6	-14	,

125272...

M5052H32S 063 5052-H32 063 Sheet

Location	Loc Oty	Loc Code	
MAT022	164.865264		
114322	25.705264		
120603	18.5		
121901	19.34		

101.32

DQA:			Date:			<u> </u>								
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE			_		AEROSPACE
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Work Orde	or.					DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS		
WOIR OIG						Rework			Skid-tube Crosstube	. [1	Water Jet	\neg	Engineering
Part N	۱o.					Scrap		Machining Small Fab			├ ─			Quality
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		ending				Bend		Folio/F	rogram	Г	Outside Dim	ensions [Pressure/Forced
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		/larks/Ch	atter			Drill Holes		Off-set						
	T	urning S	equence			Finish		Out of 0	Calibration					
	Wave/Twist in Tube				Fit/Function		Out of 9	Sequence						

DART AEROSPACE LTD	Work Order: 107686
Description: End Plate	Part Number: D3067-1
Inspection Dwg: D3067 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

		X First A	rticle [Prototype							
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments					
2.900	+/-0.010	2-906			J/2401						
2.749	+/-0.010	2.751	V								
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Measured by:	Ø.	Audited by: 09	Prototype Approval:	N/A
Date:	13-3-14	Date: 13 06	Date:	N/A

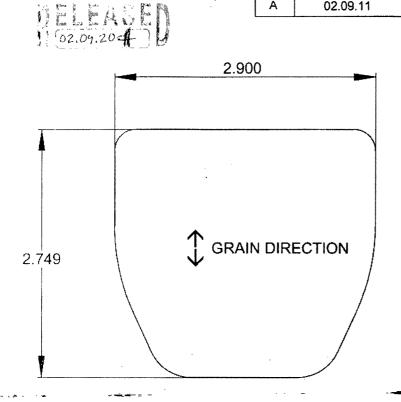
Rev	Date	Change	Revised by	Approved
Α	03.10.07	New Issue	KJ/RF	14

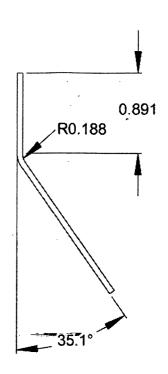
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					:	DISPOSITION			AGA		PARTMENT	· ·			
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Part N	10.					Rework Scrap			⊢	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality		
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		Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorred	ct	Temperature/Cure		
		rimp/Kin	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld		
		uffs				Contamination		Instruct	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled		
[Crushing				Countersink		Misalig	ned/off center		Positioned V		· .			
	Heat Treat				Cut Too Short		Mislabe			Power Loss/	Surge	Other			
	Inspection Strip in Tube				Drawing		Misread	d							
		//arks/Ch	atter			Drill Holes		Off-set							
		urning S	equence			Finish		Out of (Calibration						
	Wave/Twist in Tube					Fit/Function		Out of S	Sequence						

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH



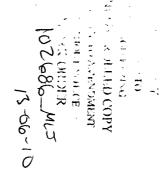
DESIG	in	DRAWN BY	DART AEROSPA HAWKESBURY, ONTAR	
CHECK	幂	APPROVED -	DRAWING NO.	REV. A SHEET 1 OF 1
DATE	02.0	09.11	END PLATE	SCALE 1:1
A	0	2.09.11	NEW ISSUE	





D3067-1 FLAT PATTERN

D3067-1-BEND DETAIL



D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRT"
 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
 OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)
 ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE IN INCHES

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DQA:			Date:			> NA DT								
OA Classel						WORK ORDER NON-CONFORMANCE / UPDATE Work Order undete only								
QA Closed: Date:						Work Order update only								
Work Order:						DISPOSITION		AGAINST DEPARTMENT/PROCESS						
						Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering	
Part No.						Scrap	Machining Small Fab			Prod. Eng. Coor.		Quality		
						Use-as-is	Thermoforming Finishing			Rec/Store/Packaging		Other		
NCR No.						Suspected Unapproved	1	Large Fab Composite			Supplier			
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FAULT CATEGORY														
Landi	ng Gear					General		-			·		_	
	Bending					Bend		Folio/Program			Outside Dim	ensions	Pressure/Forced	
	Centre Not Concentric					BOM/Route	L	Grain			Over/Under tolerance		Set-up	
	Cracks					Broken/Damage/Defect		Hardware			Part Incorrect		Temperature/Cure	
	Crimp/Kink/Ripple/Wave					Burrs		Inspection Incomplete/Unqualified			Part Lost/Missing Wel		Weld	
	Cuffs					Contamination		Instructions Incomplete/Unclear			Part Moved Wrong Stock Pull		Wrong Stock Pulled	
	Crushing					Countersink		Misaligned/off center			Positioned Wrong			
	Heat Treat					Cut Too Short		Mislabeled			Power Loss/	Surge	Other	
	Inspection Strip in Tube					Drawing		Misread						
Marks/Chatter					Drill Holes		Off-set							
Turning Sequence						Finish		Out of Calibration						
Wave/Twist in Tube						Fit/Function		Out of Sequence						